

Work Order ID 52281

Tuesday, September 22, 2009 1:26:49 PM



Page 1

Item ID: D2855-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cap

Start Date: 9/23/2009 Start Qty: 25.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 25.00



Customer:

Reference:

Approvals: Process Plan: B/mF Date: 09-9-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10467

Cast per Dwg D2855

Material Release Note Required

CZ 09/09/25 (25)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

P 09/10/09 (25)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

=> 502/6/19

counter (25) /

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Item ID: D2855-3	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Cap					
Start Date: 9/23/2009	Start Qty: 25.00		Cust Item ID:		
Required Date: 10/6/2009	Req'd Qty: 25.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Debur Cut to length as per Dwg D2855 4- Debur	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	Memo START TIME: 8:00AM OVEN TEMPERATURE: 320°F FINISH TIME: 8:30AM	0.00							

M-L 09/10/21
9/10/19 09.10.20

(25X)

=> S 02/10/30

(25X) f

=> M 09/11/04

(25X) f

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Stop



Item Name: Cap

Start Date: 9/23/2009 Start Qty: 25.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 25.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			MO 09/11/13			X25			
170 Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.00							
			MO 09/11/13			X25			
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			⇒ S orlu h			center X25			

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Item ID: D2855-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cap

Start Date: 9/23/2009 Start Qty: 25.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 25.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: *FP-5*

0.00



Packaging

Memo

0.00

Packaging

*25**09-11-16*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/11/16**ME 09-11-16*

Picklist Print

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Page 1

Work Order ID: 52281

Parent Item: D2855-3RevB

Parent Item Name: Cap

Comments:


Start Date: 9/23/2009

Required Date: 10/6/2009

Start Qty: 25.00

Required Qty: 25.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2855PRevA		Purchased	No			110	Each	47.0000	25.0000			
<div style="display: flex; justify-content: space-between;">  <div>52281 MF 09-11-16</div> </div>												

Cap

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

47

50770

47

ALS7-1032-225

Purchased

No

170

Each

877.0000

50.0000



INSERT

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

877

100895

21

100896

102

102018

102

110118

52

111529

300

111581

300

110768

X50 MD 09/11/13

SHOP COPY

RETURN

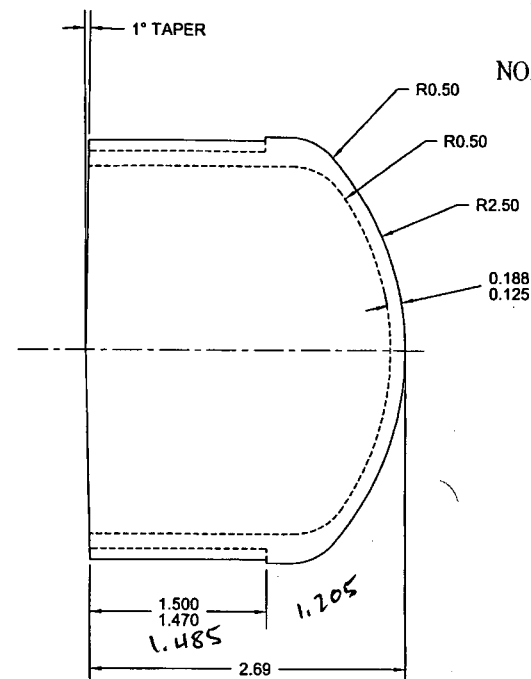
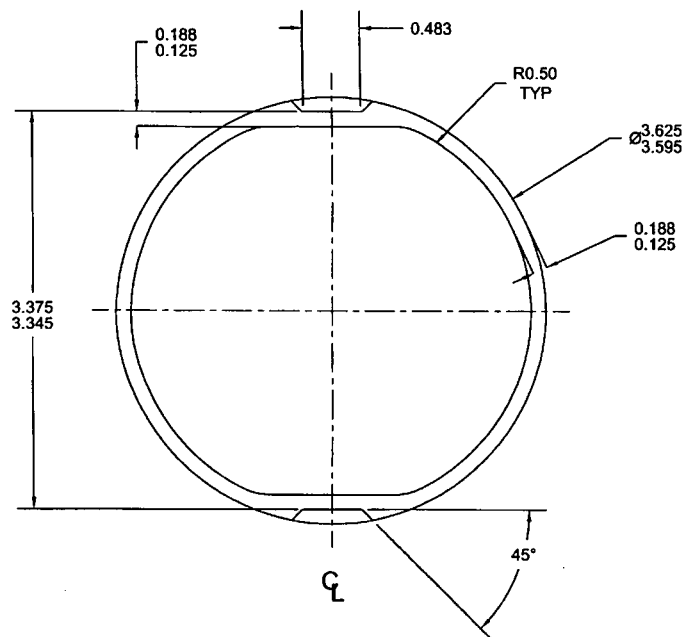
ENGINEERING
UNCONTROLLED CO.

SUBJECT TO AMENDMENTS

WITHOUT NOTICE

WORK ORDER

NO. 52281



D2855C CASTING DETAIL



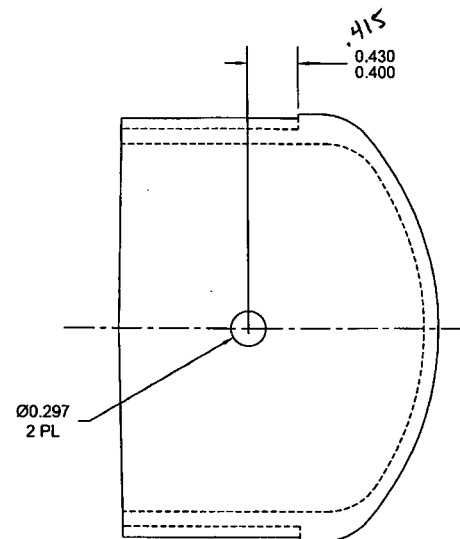
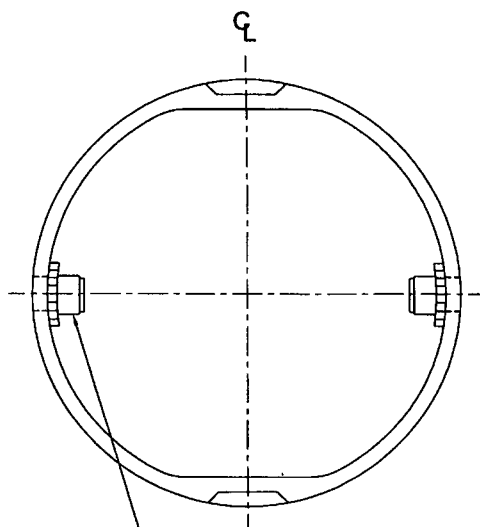
RELEASED
09/12/13 MJD

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

52281



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

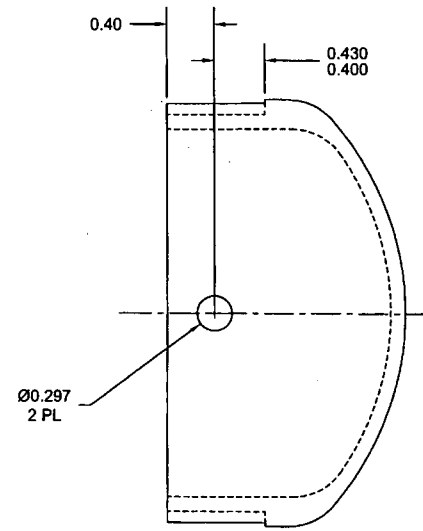
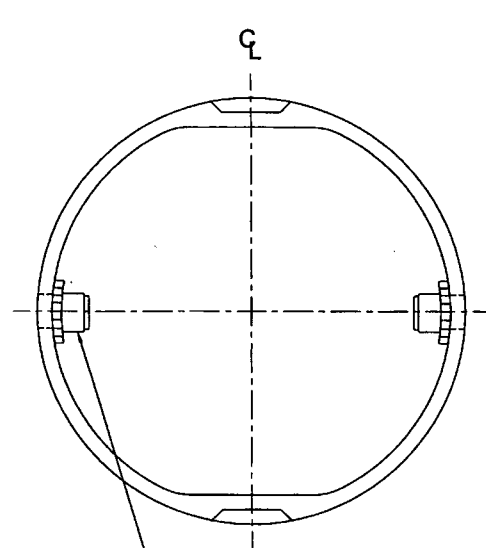
RELEASED
9/15/19

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

52281



1.205
- .415

1.620
- .400

2.020





INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, QC, H9P 1K3
Tel (514) 683 9777
Fax (514) 683 0375

email: info@foundryafpw.com

INVOICE

Invoice No.: 33157
Date: Oct 07, 2009
Ship date: Oct 07, 2009
Order No. 10467

Sold to:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKSBURY, ONTARIO K6A 1K7

Ship to:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKSBURY, ONTARIO K6A 1K7

Tel. (613) 632-5200 Fax (613) 632-5246

Item No.	Unit	Quantity	Description	Unit Price	Amount
Z098046	Each	25	D2855 CAP REV.A 3 - GST @ 5%; GST S 02/10/12	16.90	422.50 21.13
Aluminum Foundry Ltd GST: #136149242 RT0001					
Shipped By: Fedex Tracking Number:					
Comment:				Total Amount	443.63

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped**DART AEROSPACE**

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Packing

Date: **07/10/2009** Slip No. **33157, 33156****Hawksbury, ON, K6A 1K7**Vôtre No. Commande **10467, 10261**

Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
25pcs	D 2855 CAP	Z098046	A356.2	ingot#0853478
100pcs	D2855 CAP	Z098046	A356.2	ingot#0853478

Analyse
Analysis (as in Ingot)

(Si)	7.17%	(Al)	balance
(Fe)	0.087%		
(Cu)	0.0024%		
(Mn)	0.0017%		
(Mg)	0.37%		
(Zn)	<0.001%		
(Ti)	0.16%		

Donne
Yield :Résistance a la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Coc-100

Dept/Dep :
Par/Per :